



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

dec 19.
D5957
Job Sheet 168497



Part No: D5957

Job Qty: 4 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/4/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/1/17	12/1/17	0.00	0.00	Start Up Machining		<i>FK 17-12-13</i>
100	CNC Vertical Machining	4 pcs	12/2/17	12/2/17	3.66	10.81	HAAS 1		<i>SBL 17/12/14</i>
110	QC	4 pcs	12/2/17	12/2/17	0.00	0.00	QC1		<i>FK/SBL 17/12/15</i>
120	QC	4 pcs	12/2/17	12/2/17	0.00	0.00	QC8		<i>G.A 14-12-17</i>
130	HandFinish	4 pcs	12/2/17	12/2/17	0.00	0.24	HandFinish1		<i>BEB 17/12/18</i>
140	Powdercoat	4 pcs	12/4/17	12/4/17	0.00	0.19	Powdercoat1		<i>BK 17-12-19</i>
150	QC	4 pcs	12/4/17	12/4/17	0.00	0.00	QC3		<i>38</i>
160	Packaging	4 pcs	12/4/17	12/4/17	0.00	0.00	Packaging3	<i>SRL</i>	<i>3-88</i>
170	QC21-SA	4 Ea	12/4/17	12/4/17	0.00	0.00	<i>W</i> QC21		<i>57399</i>

Part Op 100 - 1-Machine as per folio D5957, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMMA016.

140 - START TIME: *8:20* *ONT. 300° FINISH 8:50*

M 138467

DAS
21
9-88

DEC 20 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-007	4	28	0	0

Part Specifications

Specifications could not be found.

Plex 11/15/17 3:05 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube Machining Thermoforming Large Fab		PART NO: D5957 Revision: Operation: Start up Operation Change No:		S021031	
Date: _____		Step #: _____		QTY Effect: _____					
Description Work Order Deviation									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/D ☐ Inspection Incompl ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes			
		OTHER: _____		☐ Fit/Function ☐ Misaligned/off center		☐ Misread ☐ Turning Sequence			

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 CANADA
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DART AEROSPACE LTD		Work Order:	162497
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

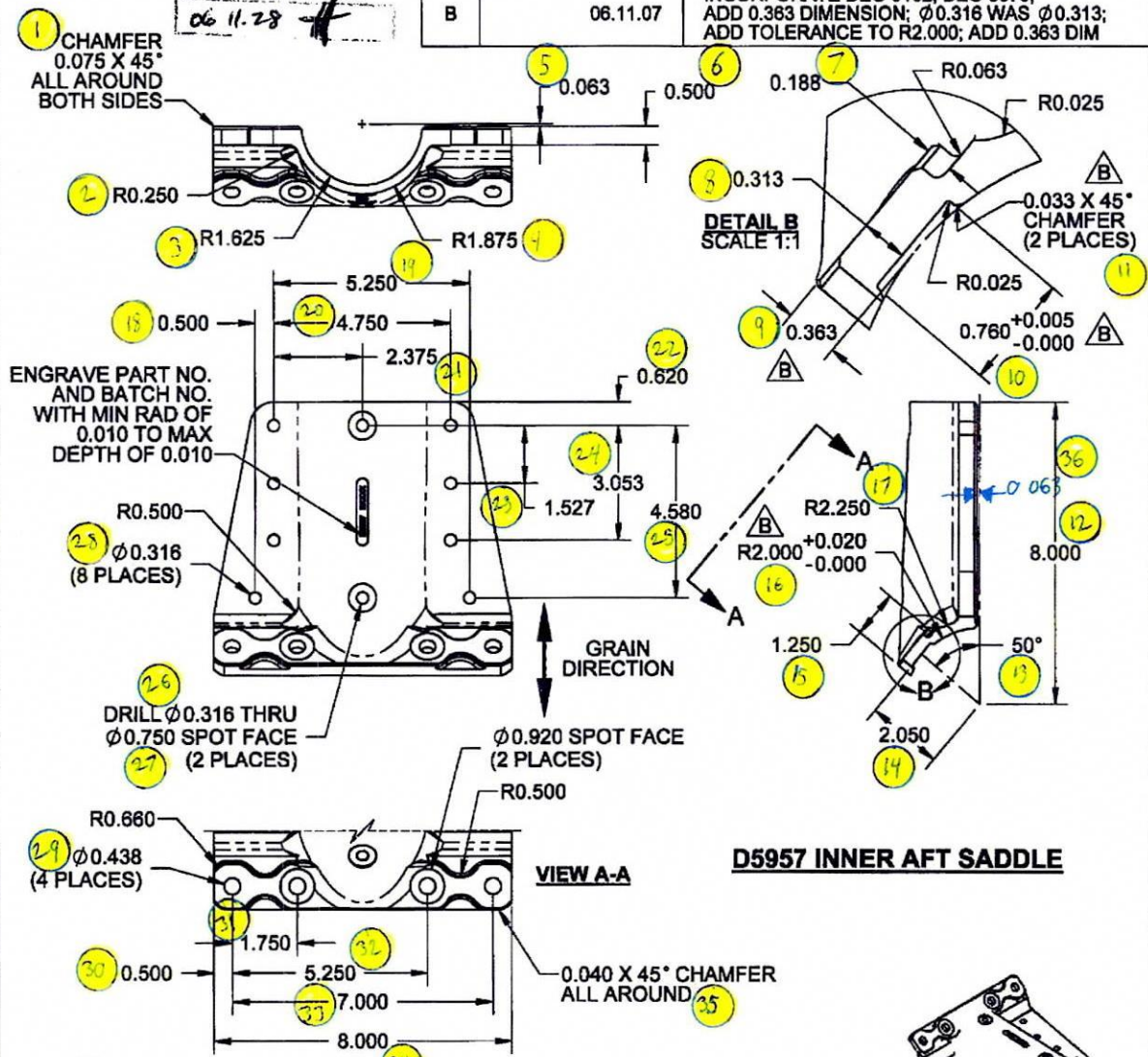
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.316	.316	.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.058	3.058	3.058		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.316	.316	.316		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.502	.502	.502		
N	1.865	1.885		1.885	1.883	1.883	1.883		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.258	2.258	2.250		
Q	0.308	0.313		.310	.300	.310	.310		
R	0.760	0.765		.762	.762	.762	.762		
S	0.490	0.510		.496	.500	.500	.498		
T	1.625	1.645		1.628	1.628	1.628	1.628		
U	2.000	2.020		2.002	2.003	2.003	2.003		
V	0.023	0.043		.030	.030	.030	.030		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>SBL F.K.</u>	Audited by: <u>A.A.</u>
Date: <u>17/12/14</u>	Date: <u>17-12-14</u>

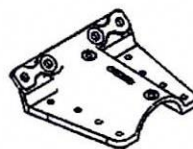
Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

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